Wednesday, 5/31/2006 7:36:08 AM

User:

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 27283

**Estimate Number** 

: 11030

P.O. Number This Issue

AlV:

: 5/31/2006

: NC, · NA

: 26564

S.O. No. : NA

: PURCHASED PARTS

Project Number

**Drawing Revision** Material

**Drawing Name** 

Part Number

**Drawing Number** 

**Due Date** 

: D2803 REV B : N/A

: D2803042

: B

:NIA : 6/20/2006

Qty:

: BRACKET ASSEMBLY

16 Um:

Each

Written By

Prsht Rev.

First Issue

**Previous Run** 

Checked & Approved By Comment

MS21043-3 was MS21042L3 KJ/JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

1.0

2.0

D28032

1.0000 Each(s)/Unit

Total:

16.0000 Each(s)

STA 84 Bracket

STA 84 BRACKET

Pick:

D28052

Comment: Qty.:

Qty Part Number Description

D2803-2

Bracket

Comment: Qty.:

1.0000 Each(s)/Unit Total:

16.0000 Each(s)

STOP Pick:

Qty

Part Number D2805-2

Description

Batch

1

Stop

3.0

D2809



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

16.0000 Each(s)

**Bushing** 

Pick:

**Qty Part Number** 

Description

D2809

Bushing

71286

Press D2805-2 into arm as per Dwg D2803

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
06-07-17	3.0	Peisec pt press fit ptit's own step after hardware picking. Permonent change.	Ē	0607.25	- (		10.07.17		
				*					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE		Description of NC	Corrective Action Section B			Verification	Annroyal		
	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector	
	·			· 					
•									
**************************************									

Part No:	PAR #:	Fault Category: NC	R:	Yes No DQA:	Date: <u>06/07/04</u>
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Wednesday, 5/31/2006 7:36:08 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: BRACKET ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D2803042 Job Number: 27283 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 4.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 5.0 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SMALL & MEDIUM FAB RESOURCE 1 7.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2809 into arm as per Dwg D2803 AN3C16A Bolt 8.0 2.0000 Each(s)/Unit Total: Comment: Qty.: 32.0000 Each(s) Bolt Pick: Part Number Description Batch Qty 2 AN3C16A **Bolt** MS210433 9.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 32.0000 Each(s) Nut Pick: Qty Part Number Description 2 MS21043-3 Nut NAS1515H3 10.0 4.0000 Each(s)/Unit Total: 64.0000 Each(s) Comment: Qty.: Washer Pick: Description Qty Part Number Washer 4 NAS1515H3 Corrosion Spray M A/R LPS-3 Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

lc

## **Dart Aerospace Ltd**

W/O:			WC	ORK ORDER CHANGES			<del></del>		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
						•			
			·						
							1		
NCR:			WORK ORD	ER NON-CONFORMANC	E (NCF	₹)			
DATE	STEP	Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
DAIE	SIEF	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date		ion C	Design Mgr	QC Inspector
ı									
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Dart No		DAD #-	Equit Catagor	NCD. V	(N-	\noa-	3)	Data	142/25

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NOTE: Date & initial all entries

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_

Wednesday, 5/31/2006 7:36:08 AM Datè: User: Kim Johnston **Process Sheet** Drawing Name: BRACKET ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D2803042 Job Number: 27283 Job Number: **Description:** Seq. #: **Machine Or Operation:** 11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2803. INSPECT WORK TO CURRENT STEP 12.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 13.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DØCUMENT CONTRØ DC 14.0 Comment: DOCUMENT CONTROL 71.00.00 } Inspection Level 21 Job Completion

## **Dart Aerospace Ltd**

W/O:			WO	<b>RK ORDER CHANGE</b>	S				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
<u> </u>									
NCR:			WORK ORDE	R NON-CONFORMAN		₹) 		<u>r</u>	T
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign		Approval Design Mgr	Approval QC Inspector	
			Design Mgr	Design Mgr	Date			:	
							-		
Part No	):	PAR #:	Fault Category	:NCR:	Yes No	DQA:		Date:	
		all entries			QA: N/C C				

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В

R0.062 (TYP)

DESIG	CP.	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
CHECH	KED M	APPROVED M	DRAWING NO.	REV. B
•	栅	- AH	D2803	SHEET 1 OF 2
DATE		· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
04.1	1.22		STA 84 BRACKET	1:3
Α		00.11.07	NEW ISSUE	
В		04.11.22	ADD CUTOUTS & -043/-044	

RELEASED 05.03 11

RO.625

В

12.411

Ø0.757±8.885 (2 PLACES) 0.125 -- 0.500 0.875±8.889 0.125 0.250 -0.250 28 888 R0.125 (TYP) SECTION B-B 0.125 SCALE 2:3

> R0.125 (TYP) -SECTION A-A 0.188 -0.562 SCALE 2:3 0.125 (ROTATED) 0.608±8:889 R0.125 (TYP) RO.300 (TYP) SECTION C-C Ø0.191±8888 (2 PLACES)

ØO.191±8.005 .420±0.001 2.654+0.000 R<sub>0.30</sub> Ø0.507±8;889 C'BORE 0.250 DEEP (TYP) 0.437+8.889 R0.625 R1.000 6.933 Ø0.507±8:889

- 13.558

SHOP COPY

RETURN TO

(ROTATED)

SCALE 2:3 (ROTATED)

> ENGINEERING UNCONTROLLED CORY

D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE) 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"

2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK WITHOUT NOTICE

3) DEBURR TO LEAVE RO.030 - 0.063 ON ALL EDGES

4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

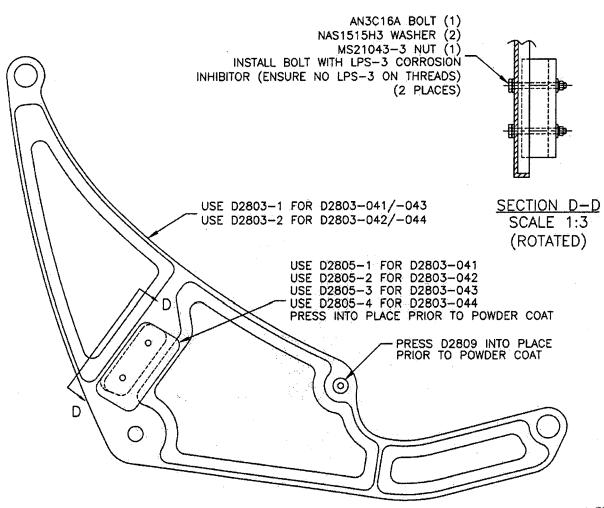
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	DRAWN BY	DART AEROS HAWKESBURY, OM	
CHECKED	APPROVED 4	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE		TITLE	SCALE
04.11.22	* *	STA 84 BRACKET	1:3



SHOP COPY RETURN TO ENGINEERING

RELEASED TROLLED COP ECT TO AMENDMEN

WITHOUT NOTICE

D2803-041/-043 BRACKET ASS'Y (SHOWN). D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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